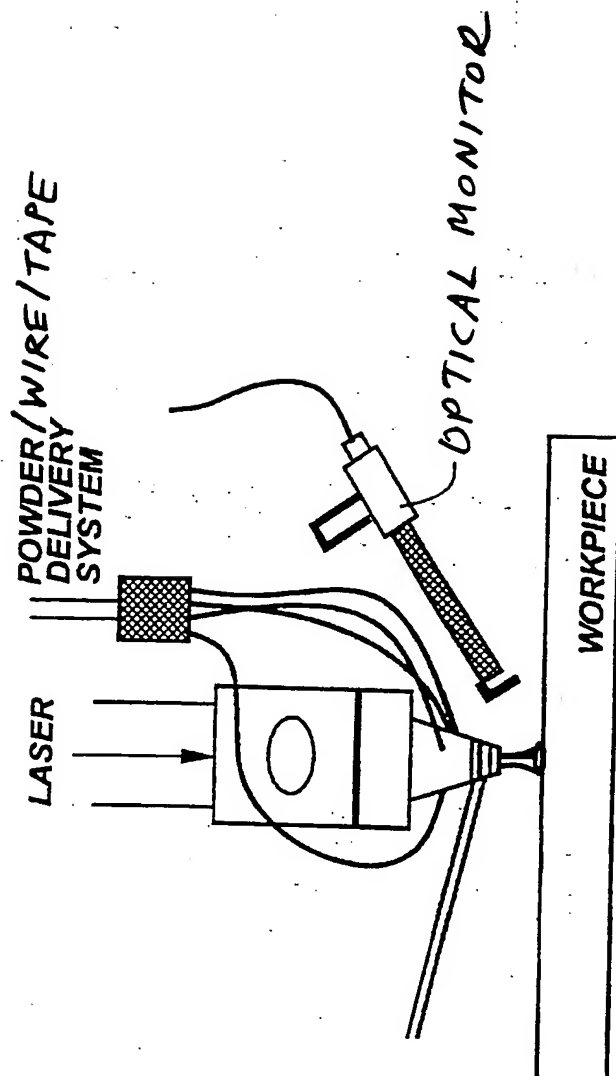
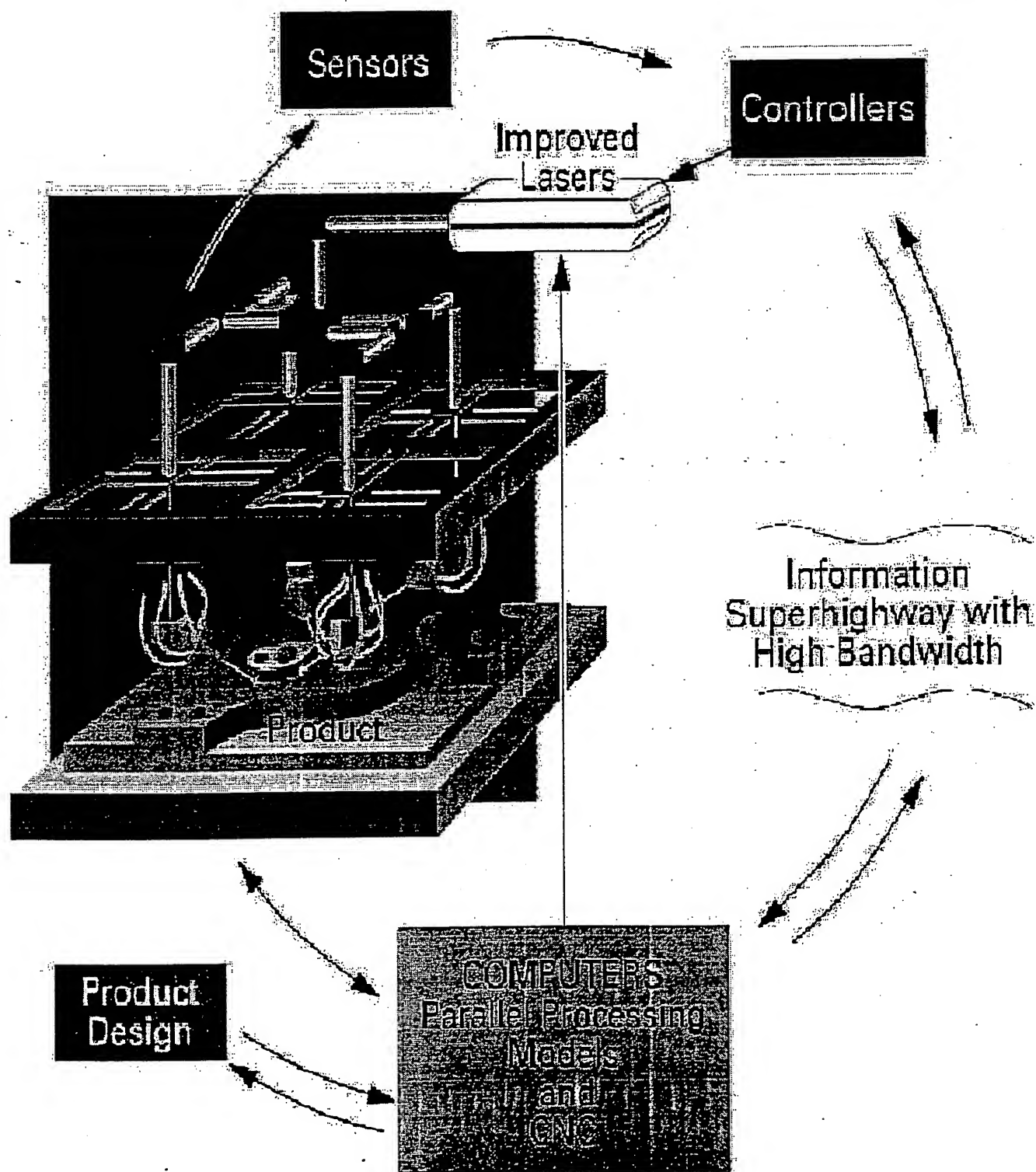
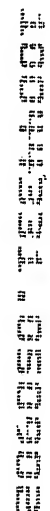


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03	00000011	03	00000011	03	00000011	03	00000011
04	00000100	04	00000100	04	00000100	04	00000100
05	00000101	05	00000101	05	00000101	05	00000101
06	00000110	06	00000110	06	00000110	06	00000110
07	00000111	07	00000111	07	00000111	07	00000111
08	00001000	08	00001000	08	00001000	08	00001000
09	00001001	09	00001001	09	00001001	09	00001001
10	00001010	10	00001010	10	00001010	10	00001010
11	00001011	11	00001011	11	00001011	11	00001011
12	00001100	12	00001100	12	00001100	12	00001100
13	00001101	13	00001101	13	00001101	13	00001101
14	00001110	14	00001110	14	00001110	14	00001110
15	00001111	15	00001111	15	00001111	15	00001111
16	00010000	16	00010000	16	00010000	16	00010000
17	00010001	17	00010001	17	00010001	17	00010001
18	00010010	18	00010010	18	00010010	18	00010010
19	00010011	19	00010011	19	00010011	19	00010011
20	00010100	20	00010100	20	00010100	20	00010100
21	00010101	21	00010101	21	00010101	21	00010101
22	00010110	22	00010110	22	00010110	22	00010110
23	00010111	23	00010111	23	00010111	23	00010111
24	00011000	24	00011000	24	00011000	24	00011000
25	00011001	25	00011001	25	00011001	25	00011001
26	00011010	26	00011010	26	00011010	26	00011010
27	00011011	27	00011011	27	00011011	27	00011011
28	00011100	28	00011100	28	00011100	28	00011100
29	00011101	29	00011101	29	00011101	29	00011101
30	00011110	30	00011110	30	00011110	30	00011110
31	00011111	31	00011111	31	00011111	31	00011111
32	00100000	32	00100000	32	00100000	32	00100000
33	00100001	33	00100001	33	00100001	33	00100001
34	00100010	34	00100010	34	00100010	34	00100010
35	00100011	35	00100011	35	00100011	35	00100011
36	00100100	36	00100100	36	00100100	36	00100100
37	00100101	37	00100101	37	00100101	37	00100101
38	00100110	38	00100110	38	00100110	38	00100110
39	00100111	39	00100111	39	00100111	39	00100111
40	00101000	40	00101000	40	00101000	40	00101000
41	00101001	41	00101001	41	00101001	41	00101001
42	00101010						

## Figure - 2







### FIGURE 4

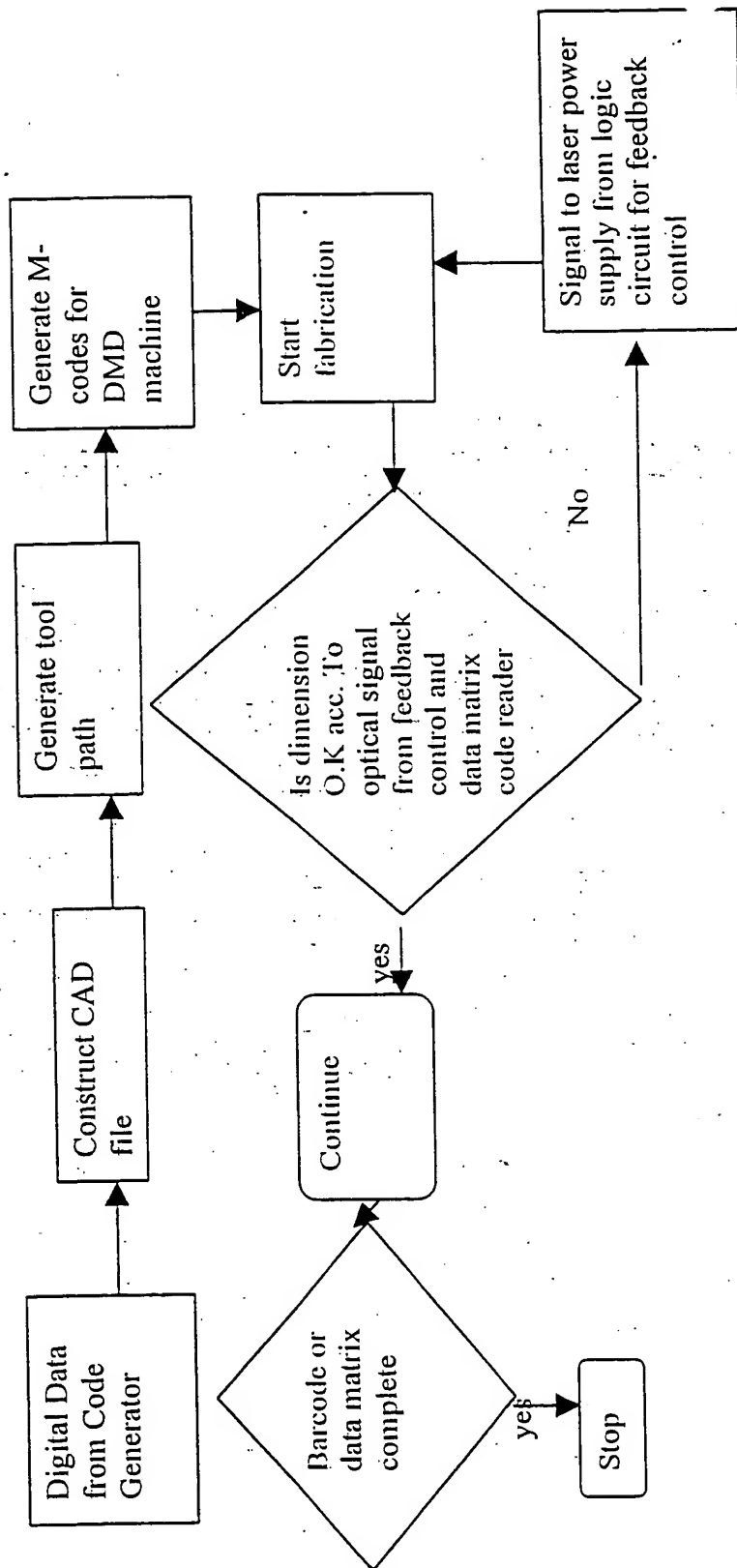


FIGURE 5



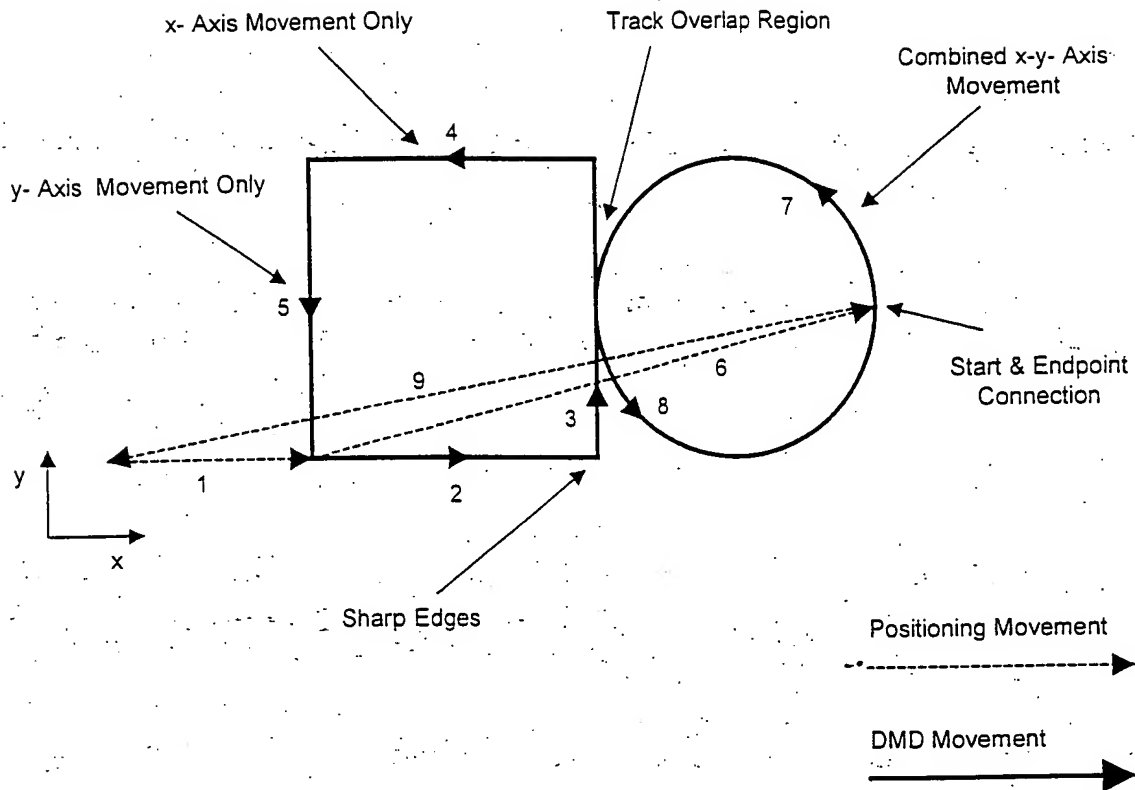
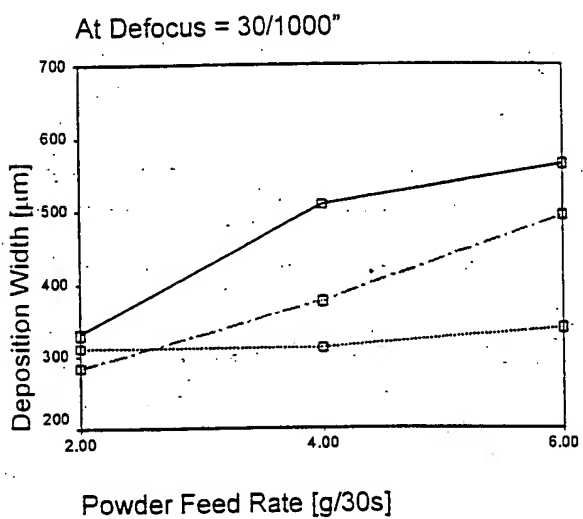
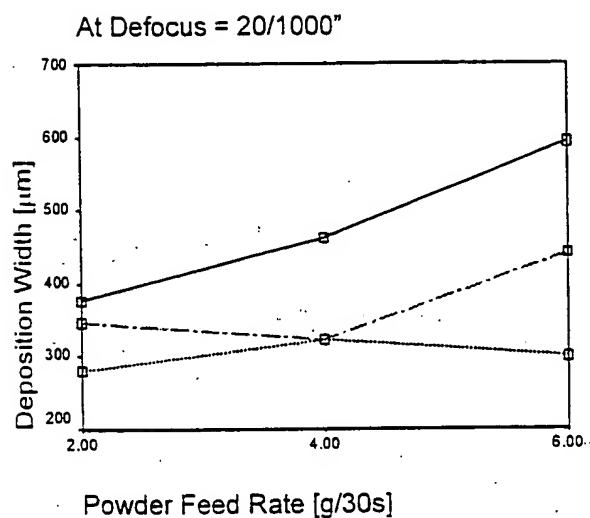
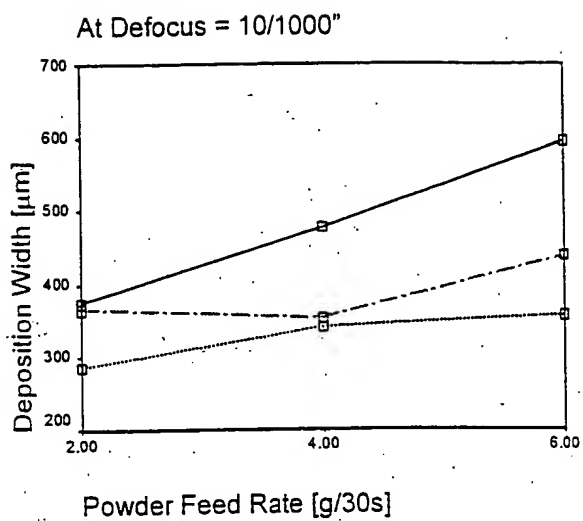


FIGURE 6

**FIGURE 7**

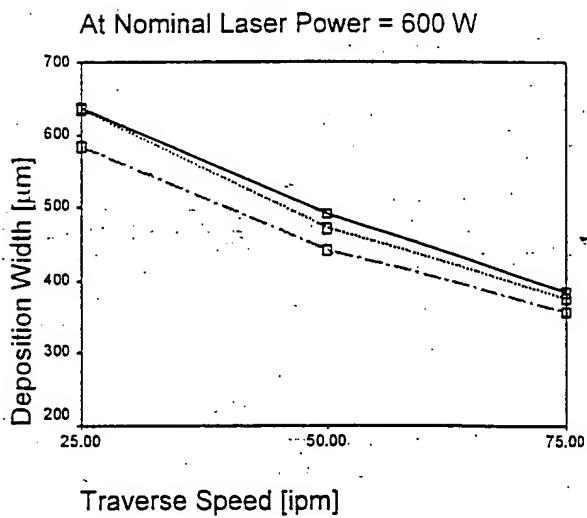
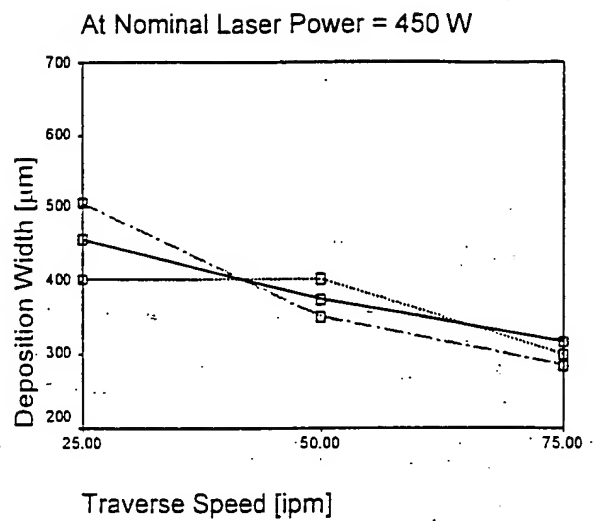
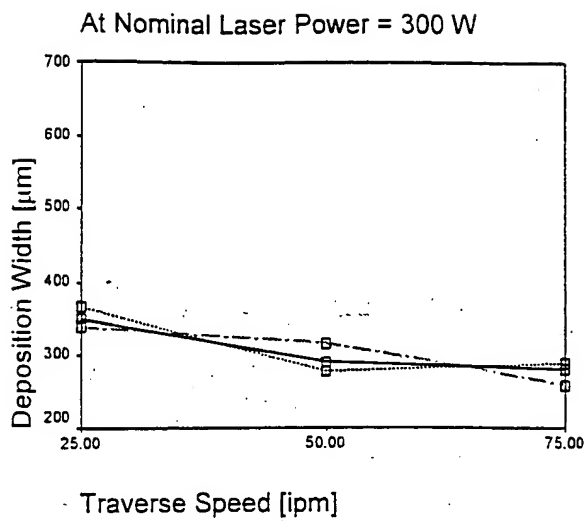


Traverse Speed [ipm]

- 75
- 50
- 25

FIGURE 8

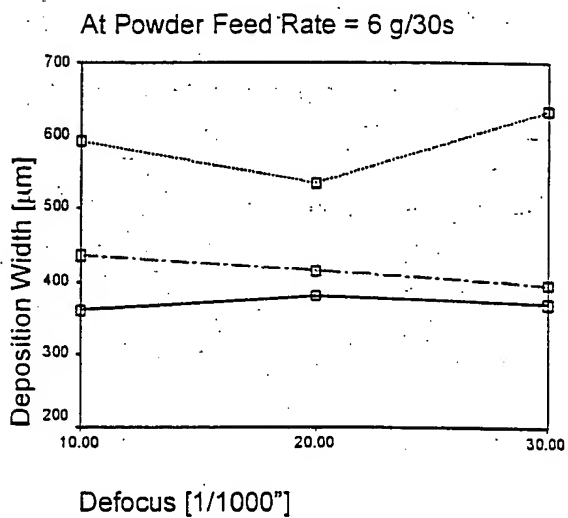
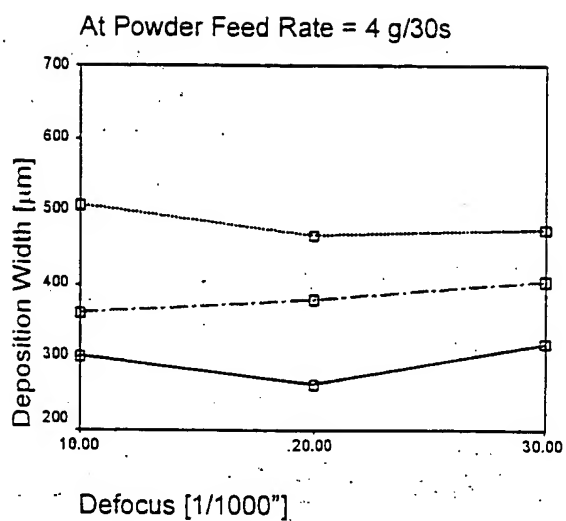
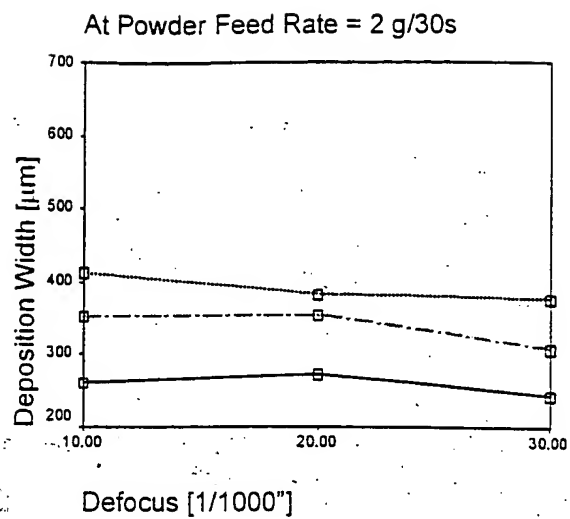




Defocus [1/1000"]

- 30
- 20
- 10

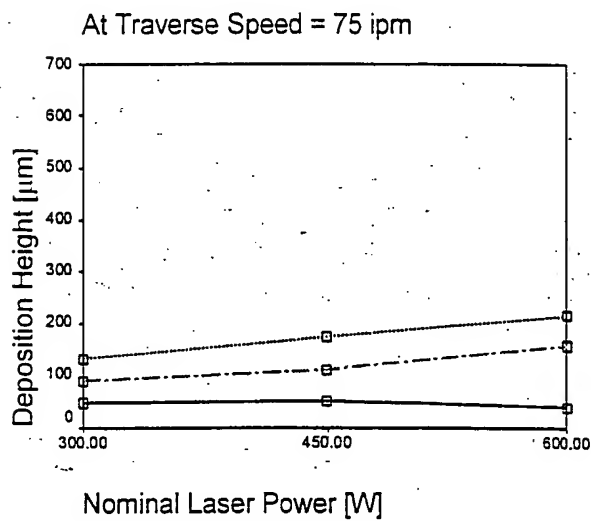
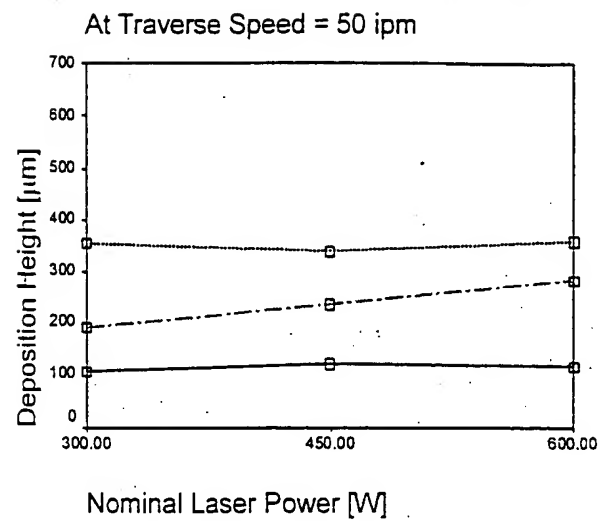
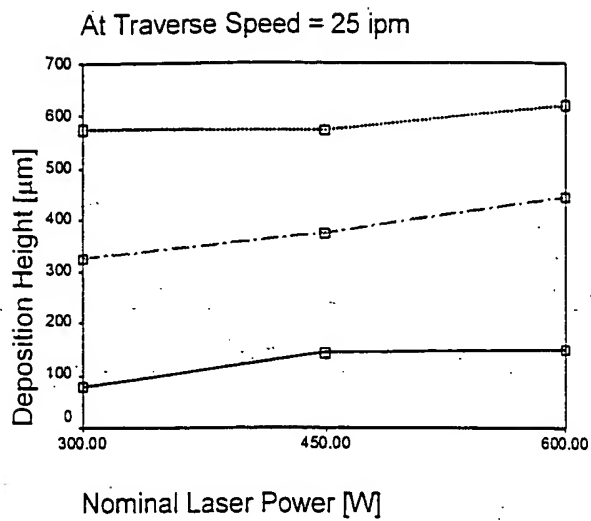
FIGURE 9



Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 10



Powder Feed Rate

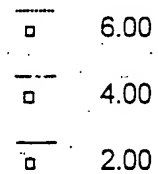
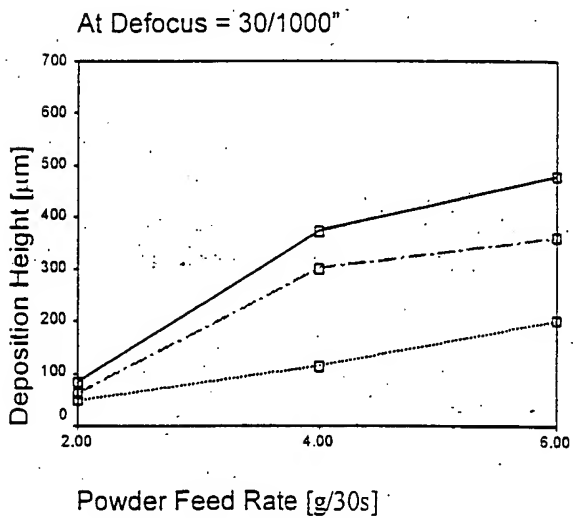
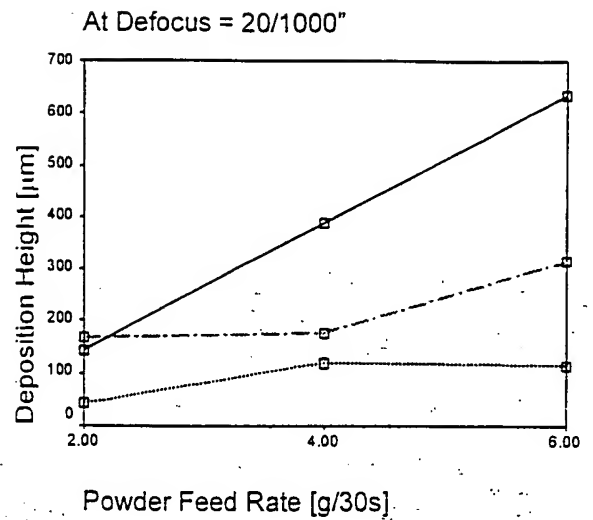
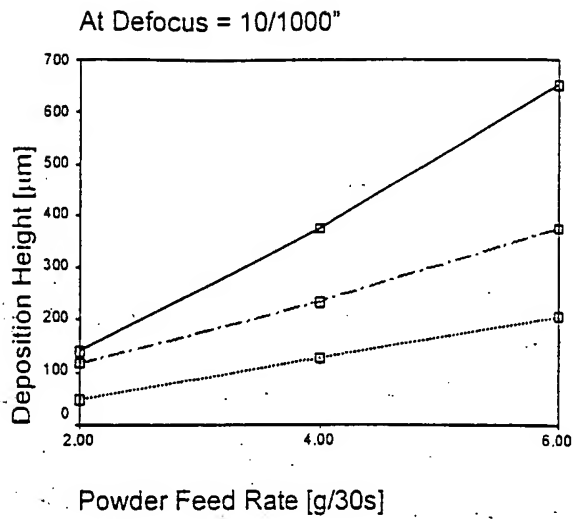


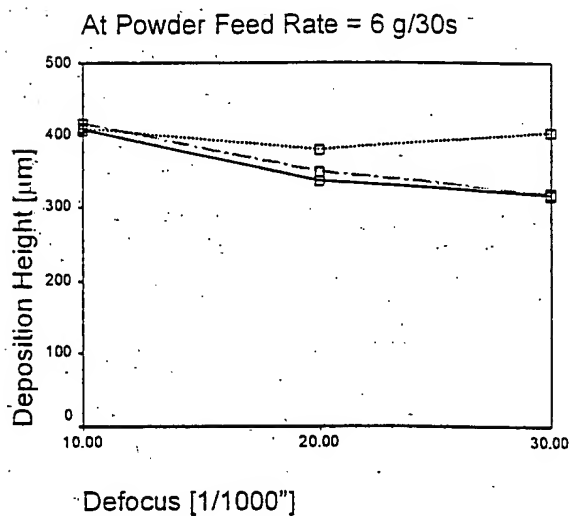
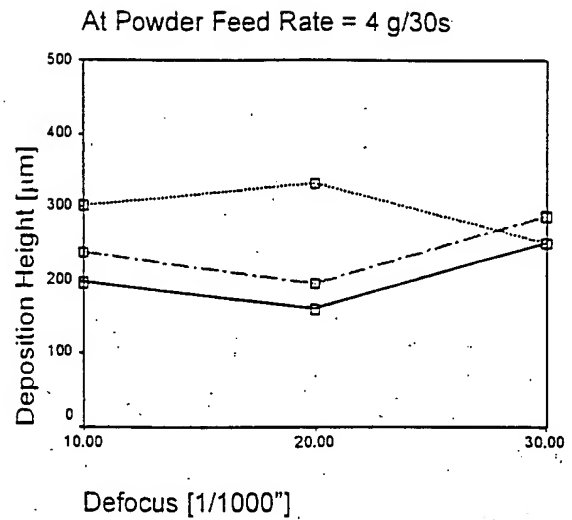
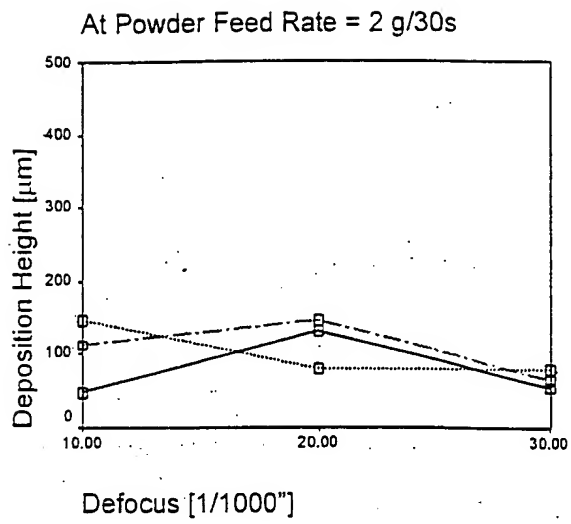
FIGURE 11



Traverse Speed [ipm]

- 75
- 50
- 25

FIGURE 12



Nominal Laser Power [W]

- 600
- 450
- 300

FIGURE 13

**FIGURE 14**